

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015891**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei / Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-242 located on PCMK SEG3004J for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U5-FCM-1.

SMAW welding of weld joint 3G-080 located on PCMK SEG3004Z for Segment 12AW the welder is identified as 051348. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4213-Tc-U4b-2.

FCAW welding of weld joint 3G-046 located on PCMK SEG3004Z for Segment 12AW the welder is identified as 201215. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

SMAW welding of weld joint 4G-004 located on PCMK CA3009 for Segment 12BW the welder is identified as 067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

During random in-process observation of the Critical Weld Repair (CWR) in Segment 12AW, this Caltrans

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Quality Assurance Inspector (QA) discovered the following issue:

-The approved Critical Weld Repair (CWR) was completed using the Flux Core Arc Welding process (FCAW).

This CWR describes using the Shielded Metal Arc Welding (SMAW) process for these repairs.

For more information please see the Incident report

04-0120F4_TL-15_B247_07-14-10_12AW_CWR_Not_Followed

OUTSIDE SHOP

11DE

SMAW welding of weld joint 4F-177 located on PCMK SSD17-PP105 for Segment 11DE the welder is identified as 067589. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

During in process visual inspection it is found that Fit-up of Drip plate(X339G) over the deck panel of segment 11DE is identified as DP707A at Cross beam side, two additional splice welds were added to the drip plate. These welds are not identified by ZPMC on the current weld map. This is informed to ZPMC QA Mr. Zhang wei and ABF QA Mr. Peter shaw for joint design change.

11EE

SMAW welding of weld joint 3F-207 located on PCMK SSD29-PP107.5 for Segment 11EE the welder is identified as 201087. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2113-FCM-1.

BAY#16

SAW welding of weld joint 1G-002 located on PCMK BP3074-001 for Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

BAY#19

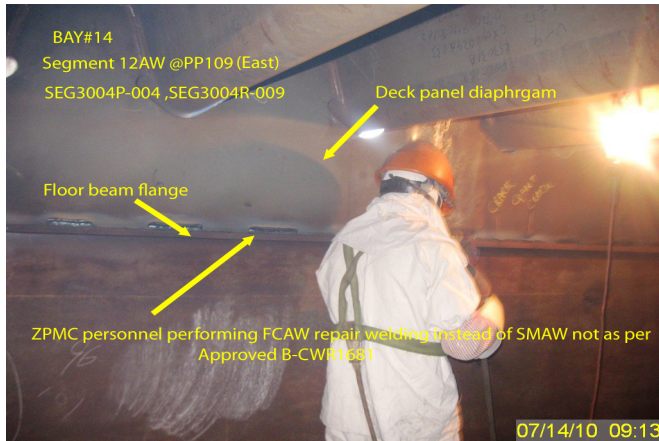
FCAW welding of weld joint 2G-007 located on PCMK BK004A8 for OBG bike path the welder is identified as 062749. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-P4-F.

Fit-up of bearing plate is in progress on Bike path BK004A-011.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra
Reviewed By:	McClendon,Timothy

Quality Assurance Inspector
QA Reviewer
